

Work Order ID 50045



Page 1

July 6, 2009 1:31:30 PM

Item ID: D212-664-101

Accept



Setup Start



Revision ID: C

Stop



Item Name: Crosstube Fwd

Start Date: 07/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 16/07/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D212-664-141

Rev C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP D212-664-101 CHG003

509/02/24

09/07/23

110

0.00



Packaging

Packaging

Memo

0.00

Packaging

09/12/14

120

0.00



BENDING MACHINE - CROSSTUBES

CNC Bend 2

Memo

0.00

CNC Alpha 160 Bender

Bend tube as per Dwg D212-664-141 using CNC bender program 212-fw and Folio FT015

MB 09-07-13

1X

Work Order ID 50045

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Page 2

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Accept



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Revision ID: C

Stop



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Start Date: 07/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 16/07/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start



QC: Date:

SPC (Y/N): Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC15- Crosstube Dimensional Check

0.00



QC

Memo

0.00

Quality Control

140

Crosstubes

0.00



Crosstubes

Memo

0.00

Crosstubes

1-Drill pilot holes in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549 □2-Ream hole to finish size in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549. Check dimensions between holes, both sides on both cuffs, to ensure alignment wi

MB
09-07-14
AWM

150

Crosstubes Chemical Conversion

0.00



HandFXtube

Memo

0.00

Hand Finishing Crosstubes

Chemical Conversion Coat within 24 hours of bending and drilling

AWM 9-7-14

Work Order ID 50045



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Item ID: D212-664-101

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Cust Item ID:

Required Date: 16/07/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Inspect for damage & ensure results are as per Dwg D212-664-141

RT 09-07-20

200

SprayPaint

0.00



SprayPaint

Memo

0.00

Spray Painting

1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube with White Imron as per QSI 005 4.2

☐ PRIME: ☐ Start

Time: 10:30 ☐ Finish Time: 11:30 ☐ PAINT: ☐ Start

Time: 3:06 ☐ Finish Time: 4:20

=> ml 09 07 20 (1)

210

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

Then, Wrap in plastic bag to protect from scratches

RT 09-07-21

Work Order ID 50045

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Item ID: D212-664-101

Accept



Setup Start



Revision ID: C

Stop



Item Name: Crosstube Fwd

Start Date: 07/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 16/07/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

220

0.00



Crosstubes

Crosstubes

Memo

0.00

Crosstubes

1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe □ 2-Install supports with magnobond as per QSI 015 Adhere for for 12 Hrs □ A/R 6398 Magnobond Batch: 111249 exp: 02/2010 Torque: ml 09 07 23 ①

⇒ ml 09 07 22 ①

230

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ 802/4/03

⑩

⌘

240

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

⌘ 9/7/23 ①

Work Order ID 50045

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Page 6

Item ID: D212-664-101

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Setup Start



Revision ID: C

Stop



Item Name: Crosstube Fwd

Start Date: 07/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 16/07/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

250

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

502/07/2009

①

φ

Quality Control

260

Packaging

0.00



Packaging

Memo

0.00

Rev E

9/7/24 ① SC

Packaging

Identify and pack for shipping as per PPP D212-664-101

270

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

09/07/23 AJ

Quality Control

u 59.07.27

Picklist Print

July 6, 2009 1:31:29 PM

Work Order ID: 50045

Parent Item: D212-664-101RevC

Parent Item Name: Crosstube Fwd



Comments:

Start Date: 07/07/2009



Required Date: 16/07/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN6-35A  BOLT		Purchased	No			250	Each	42.0000	4.0000 		9/7/23	OK

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	42	
111605	42	

AN6-36A  Bolt		Purchased	No			250	Each	77.0000	4.0000 			
--	--	-----------	----	--	--	-----	------	---------	---	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	77	
109632	1	
110382	26	
111650	50	

11/0605 YP

9/7/23 OK

11/0382 YP

Picklist Print

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Page 2

Work Order ID: 50045

Parent Item: D212-664-101RevC

Parent Item Name: Crosstube Fwd


Start Date: 07/07/2009

Required Date: 16/07/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD616  Washer		Purchased	No			250	Each	484.0000	18.0000		9/7/23 <i>LC</i>	

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	484	
107242	3	
107959	6	
109371	8	
110704	23	
111193	18	
111607	426	

D212-664-101TRNRevC Manufactured No

220 Each 2.0000 1.0000



Crosstube Turning Detail

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FG	2	
48316	1	
48317	1	

111607 184

1x MB 09-07-13

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Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 50045

Parent Item: D212-664-101RevC

Parent Item Name: Crosstube Fwd


Comments:

Start Date: 07/07/2009

Required Date: 16/07/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2893-1RevB 		Manufactured	No			220	Each	78.0000	2.0000			
2.75 Support												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	78	
25657	6	
43479	16	
46488	18	
47109	18	
47637	20	

m.m. 070708

D3428-1RevA



Placard

Manufactured No

250 Each 18.0000 1.0000



9/7/23 LC

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	18	
47310	8	
48359	10	

47310 10

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Shop Packet Print

Page 3

Picklist Print

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Page 4

Work Order ID: 50045

Parent Item: D212-664-101RevC

Parent Item Name: Crosstube Fwd


Comments:

Start Date: 07/07/2009

Required Date: 16/07/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3595-063-450RevA		Manufactured	No			220	Each	63.8000	4.2105			
 RUBBER CUSHION												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 63.8

38959 2

43210 12.8

46465 49

MS21042L6

Purchased

No

100

Each

803.0000

6.0000

Nut

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 803

105077 22

110002 275

111548 100

111578 400

19099 6

mt. m 09 07 22

9/1/23

m110002 6x R

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Page 4

Picklist Print

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Page 5

Work Order ID: 50045

Parent Item: D212-664-101RevC

Parent Item Name: Crosstube Fwd

Comments:

Start Date: 07/07/2009

Required Date: 16/07/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21920-25		Purchased	No			250	Each	164.0000	4.0000			



Clamp(per MIL-DTL-8783C)



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	164	
107456	2	
108111	3	
108975	17	
109181	48	
109644	10	
111282	50	
111429	25	
111883	9	

M.M 09.07.22

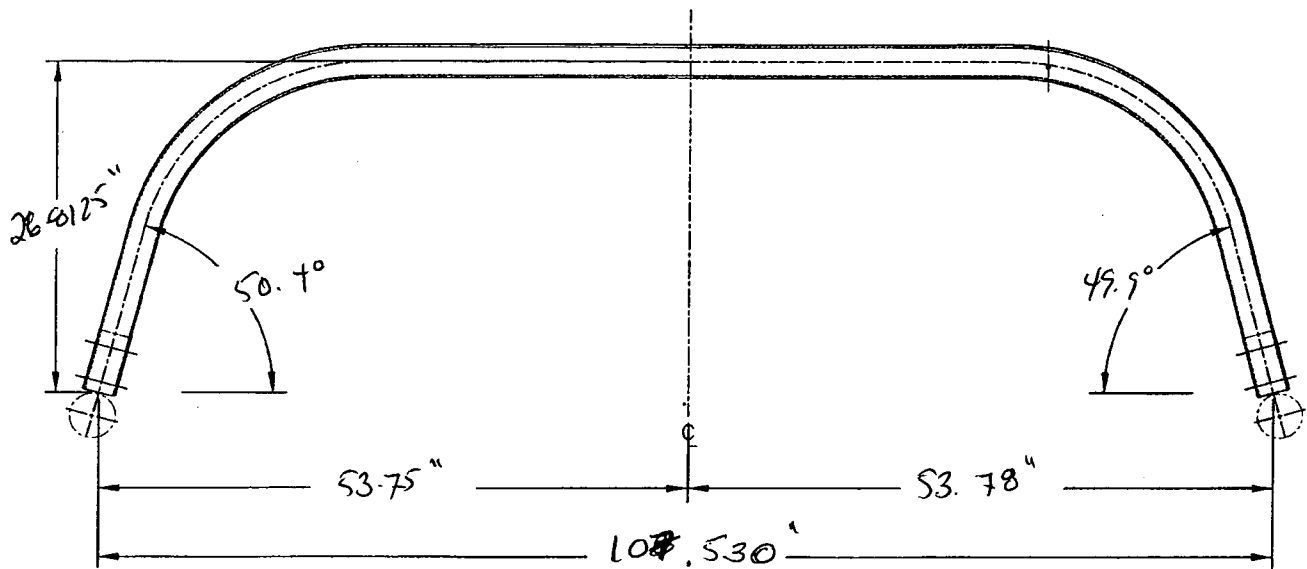
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Shop Packet Print

Page 5

DART AEROSPACE LTD		Work Order:	50045
Description: Crosstube High Fwd (205/212/412)		Part Number:	D212-664-101
Inspection Dwg: D212-664-141 Rev: C		Page 1 of 1	

Required Dimension	Min	Max
Height	26.79	27.05
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.7



Comments

QC15 Inspection	C
Date	07/07/13

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.31	Dimensions updated per Dwg Rev C	KJ/JM	



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED GP	APPROVED [Signature]	DRAWING NO. D212-664-141	REV. C SHEET 1 OF 3
DATE 07.03.08		TITLE XTUBE ASS'Y (205/212/412 HI FWD) NTS	
A	00.12.12	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
C	07.03.08	REMOVE -851 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	

RELEASED

07.04.24

DEO ATTACHED

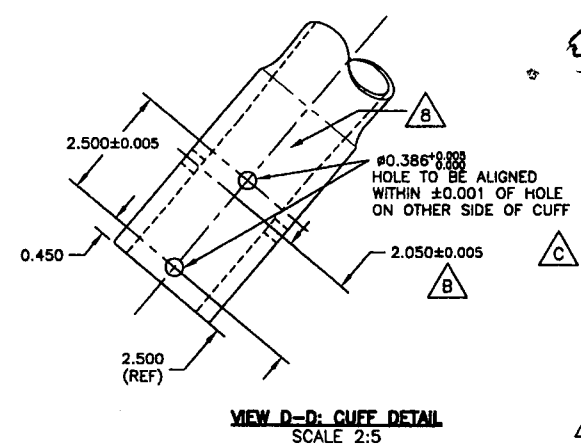
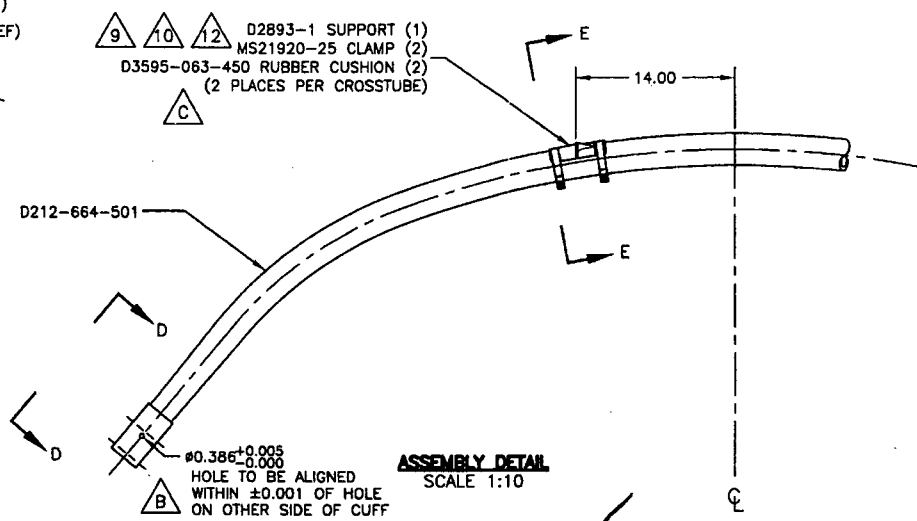
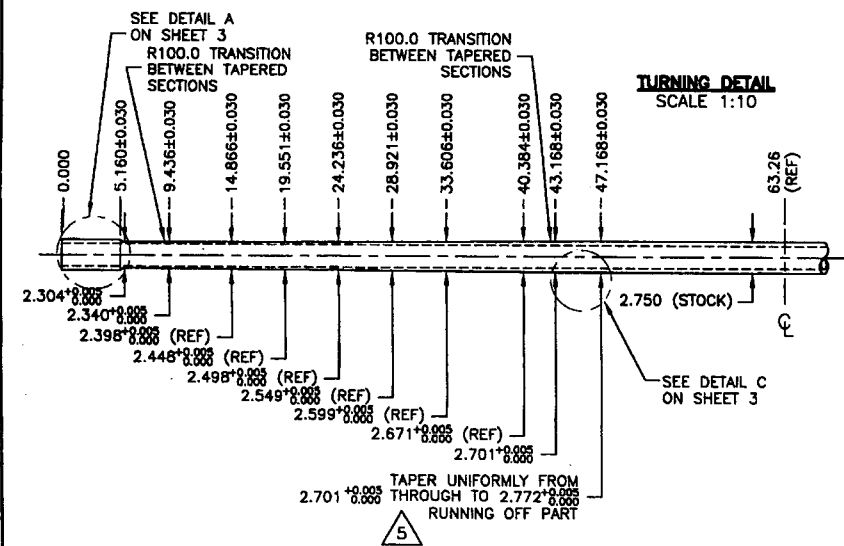
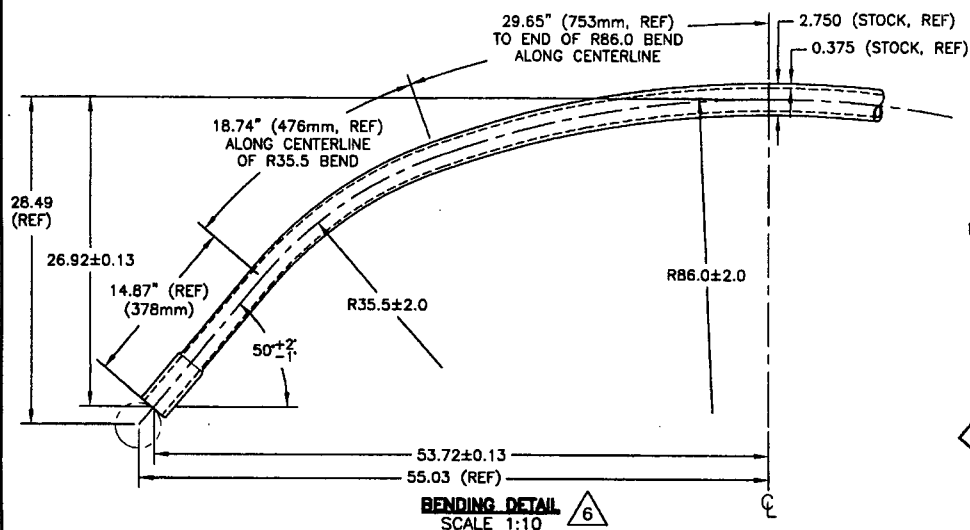
Qty	Part Number	Description
X	D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
1	D6005-128	CROSSTUBE
2	D2893-1	SUPPORT
4	D3595-063-450	RUBBER CUSHION
4	MS21920-25	CLAMP (OR MS21920-26)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6005-128
FINISHED LENGTH = 126.51±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 10) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2893-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT
- 11) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

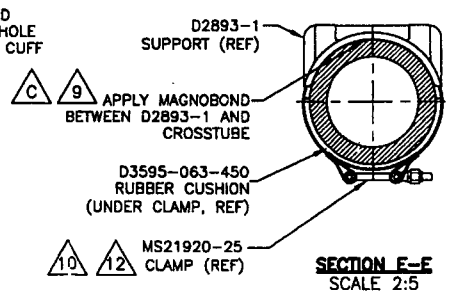
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50045

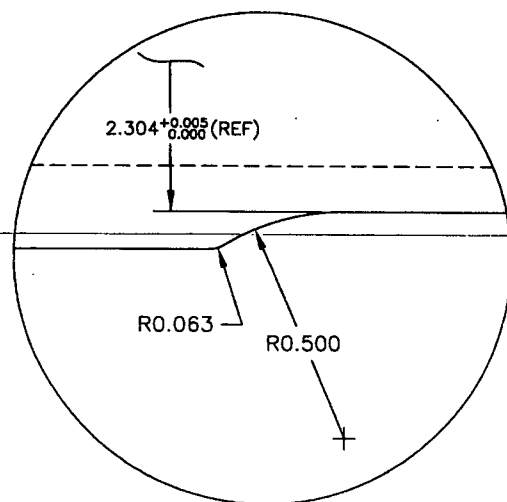
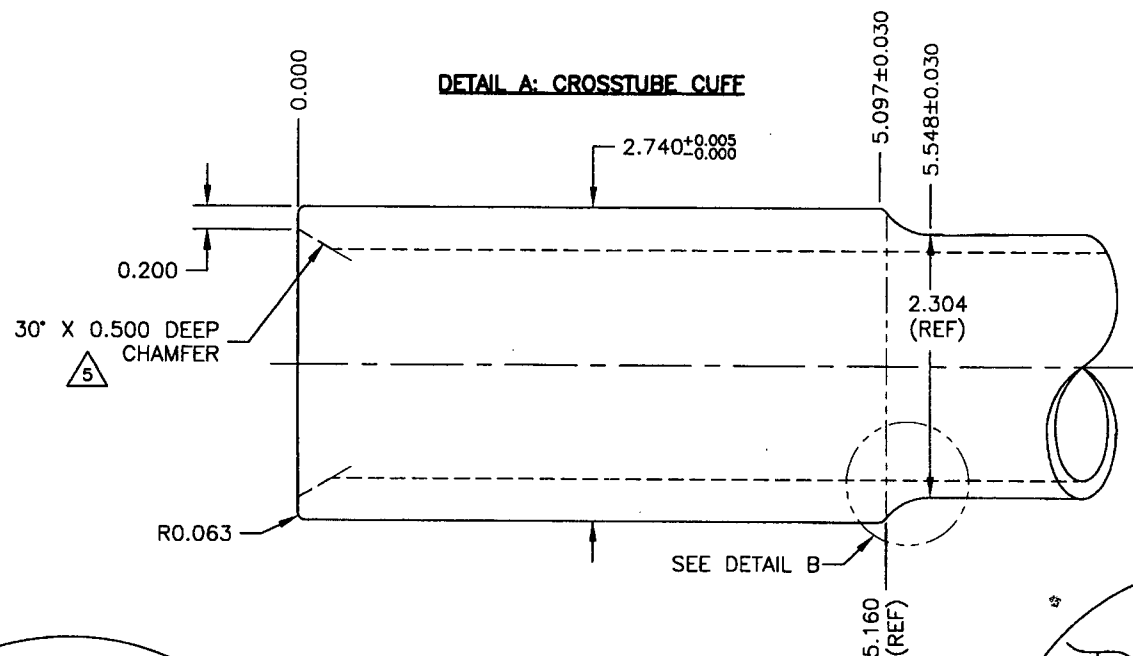
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07.04.24
DEO ATTACHED



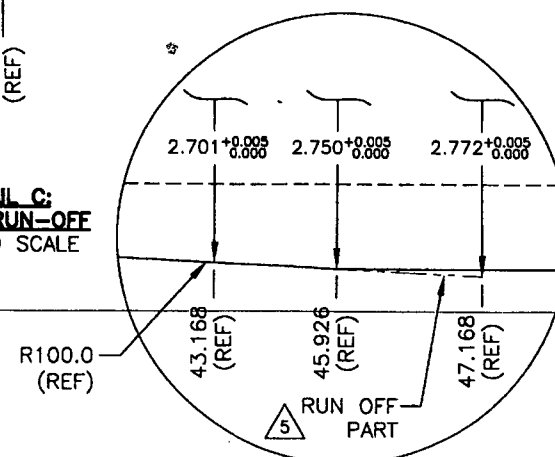
COPYRIGHT © 2000 BY DART AEROSPACE LTD.		DESIGN	PH	DRWN BY	PH	DART	DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED	92	APPROVED	4	DRAWING NO.	REV. C
		DATE	07.03.08			D212-664-141	SHEET 2 OF 3
						XTUBE ASS'Y (205/212/412 HI FWD)	SCALE 1:10

RELEASED
87.04.24 (P)
PER ECLN 887

DEO ATTACHED



DETAIL C: TAPER RUN-OFF
NOT TO SCALE



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DESIGN	PH	DRAWN BY	PH	DART	DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED	J	APPROVED	[Signature]	DRAWING NO. D212-664-141	REV. C SHEET 3 OF 3
DATE	07.03.08	TITLE	XTUBE ASS'Y (205/212/412 HI FWD)		
		SCALE	1:1		

DRAWING NO. D212-664-141	TITLE CROSSTUBE	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D212-664-141-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>AD</i>	CHECKED <i>RS</i>	MFG. APPR. <i>EE</i>	APPROVED <i>MD</i>		DE APPR. <i>TH</i>		
DATE 09.05.01	DATE 09.06.15	DATE 09.06.15	DATE 09/06/16		DATE 09/06/16		

CHANGE:

ADD THE FOLLOWING CROSSTUBE ASSEMBLY:

Part Number	Description
D212-664-141B	CROSSTUBE ASSEMBLY (214 HIGH FWD)

THE D212-664-141B CROSSTUBE HAS THE SAME PARTS LIST AS THE D212-664-141 CROSSTUBE. HOWEVER, INSTALL THE SUPPORTS AS SHOWN IN FIGURE 1 OF THIS ENGINEERING ORDER. THE NEW KIT IS OTHERWISE ASSEMBLED PER THE D212-664-141 CROSSTUBE.

RELEASED
07/06/22

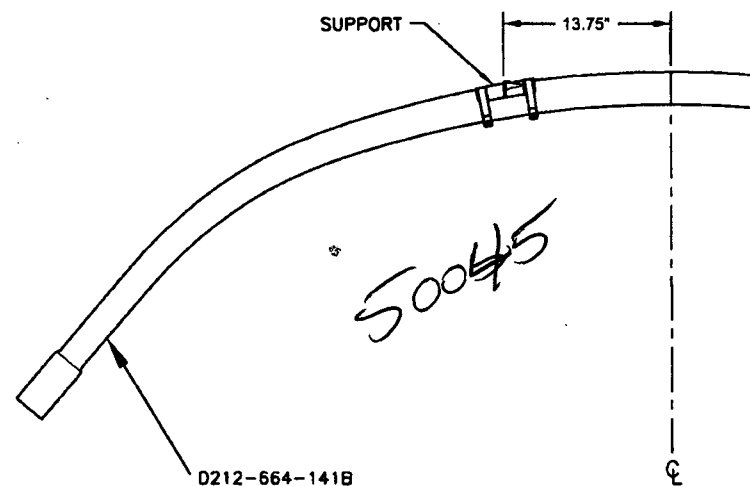


FIGURE 1 - SUPPORT INSTALLATION

5.0 PARTS LIST

5.1 HIGH GEAR CROSSTUBES

Item	-101	-201	-203	Part Number	Description
	X			D212-664-101	CROSSTUBE INSTALLATION, 204/205/210/212/214/412, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K HIGH FWD
		X		D212-664-201	CROSSTUBE INSTALLATION, 204/205/210/212/214, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K HIGH AFT
			X	D412-664-203	CROSSTUBE INSTALLATION, 412 HIGH AFT
1	1			D212-664-141	CROSSTUBE ASSEMBLY, 204/205/210/212/214/412, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K HIGH FWD
2		1		D212-664-241	CROSSTUBE ASSEMBLY, 204/205/210/212/214, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K HIGH AFT
3			1	D412-664-243	CROSSTUBE ASSEMBLY, 412 HIGH AFT
10	2			* D2893-1	SUPPORT
11	4			* D3595-063-450	RUBBER CUSHION
12	4			* MS21920-25	CLAMP (OR MS21042-26)
13	4			AN6-35A	BOLT
14	4			AN6-36A	BOLT
15	6			MS21042L6	NUT (OR MS21042-6)
16	18			AN960JD616	WASHER
20		2		* D2940-1	SUPPORT
21		4		* D3595-063-530	RUBBER CUSHION
22		4		* MS21920-28	CLAMP (OR MS21042-30)
23		4		AN6-40A	BOLT
24		2		AN6-41A	BOLT
25		6		MS21042L6	NUT (OR MS21042-6)
26		18		AN960JD616	WASHER
30			1	* D2896-1	SUPPORT
31			2	* D2856-600-1009	ABRASION STRIP
32			2	* D3595-063-570	RUBBER CUSHION
33			4	* MS21920-28	CLAMP
34			2	* MS21920-30	CLAMP (OR MS21042-32)
35			4	AN6-40A	BOLT
36			2	AN6-41A	BOLT
37			6	MS21042L6	NUT (OR MS21042-6)
38			18	AN960JD616	WASHER
39			2	* D3189-1	CHAFING SHIELD
50	1	1		D3428-1	PLACARD

REFERENCE ONLY

*REFERENCE ONLY. PARTS ARE INCLUDED IN D212-664-141/-241 OR D412-664-243 ASSEMBLIES ABOVE
NOTE: KITS INCLUDE EXTRA HARDWARE FOR COMPATIBILITY WITH BOTH DART AND BELL/AA
SKIDTUBES.

50045



LIQUID PENETRANT TEST REPORT

P- 14943

CLIENT	DART AEROSPACE	DATE	July 16-2009	PAGE	1	OF	1	
ATTENTION	LINDA/CHATEL	ACUREN JOB NO.	188-09-001468	TIME	AM	<input checked="" type="checkbox"/>	PM	<input type="checkbox"/>
ADDRESS	1270 ABERDEEN ST. HAWKESBURY, ON. K6H 1K7	PO/NO No.		WORK LOCATION	HAWKESBURY			
PROJECT	F.P.I. ON CROSS TUBES	ACCEPTANCE STD.	ASTM 1417	REV./DATE	2007			
ITEM(S) EXAMINED	6 - X - TUBES							

JOB DESCRIPTION	PROCEDURE NO. LT-XXX	REV./DATE	TECHNIQUE NO. LT-XXXX-XXX	REV./DATE
PART NO.	MATERIAL		THICKNESS	
SCOPE	WET FLUORESCENT LIQUID PENETRANT INSPECTION CARRIED OUT 100% EXTERNAL			

TEST DETAILS	
METHOD	<input checked="" type="checkbox"/> FLUORESCENT <input type="checkbox"/> VISIBLE
FAMILY BRAND	MAGNA FLUX
PENETRANT	ZL 67
PENETRANT REMOVER	H2O
DEVELOPER	SKD 52
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS <input type="checkbox"/> AQUEOUS <input type="checkbox"/> DRY
MINIMUM DWELL TIME	45 MIN.
MINIMUM DRY TIME	>10 MIN.
MINIMUM DWELL TIME	10 MIN.
WATER WASH	<input checked="" type="checkbox"/> WATER WASH <input type="checkbox"/> SOLVENT REMOVABLE <input type="checkbox"/> POST EMULSIFIED
BLACK LIGHT S/N	16459
OUTPUT	> 1000 μ W/cm ²
FLASHLIGHT	<input type="checkbox"/> FLASHLIGHT <input type="checkbox"/> TROUBLELIGHT
OUTPUT	>100 fc @ SURFACE
OTHER	LAB NO
LIGHT METER S/N	
CAL DUE DATE	DEC 8-2009

TEST SURFACE	
SURFACE CONDITION	<input type="checkbox"/> AS GROUND <input type="checkbox"/> AS WELDED <input checked="" type="checkbox"/> MACHINED <input type="checkbox"/> SHOT BLASTED <input checked="" type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < -4°C/ 20°F <input type="checkbox"/> -4°C/ 20°F TO 10°C/50°F <input checked="" type="checkbox"/> 10°C/50°F TO 52°C/125°F <input type="checkbox"/> > 52°C/125°F

RESULTS-	<input type="checkbox"/> METRIC <input type="checkbox"/> IMPERIAL
Work order #	
1 - 50081	✓
1 - 50094	✓
1 - 50045 ✓	✓
1 - 50019	✓
1 - 50038	✓
1 - 50044	✓
No RELUVANT INDICATIONS WERE FOUND ON THESE SIX CROSS TUBES	

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES	
CLIENT REPRESENTATIVE	DTR # E-27929
TECHNICIAN (SIGNATURE):	REPORT REVIEWED BY:
NAME (PRINT):	NAME INITIALS
CGSB LEVEL	CGSB LEVEL
CGSB REG. NO.	CGSB REG. NO.